

Work Order ID 67231

Monday, March 14, 2011 6:41:13 AM



Page 1

Item ID: D3417-9

Accept



Setup Start



Revision ID:

Item Name: Washer

Stop



Start Date: 3/14/2011 Start Qty: 20.00



Cust Item ID:

Required Date: 3/17/2011 Req'd Qty: 20.00



Customer:

Reference:

11/03/14

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

Draw Nbr	Revision Nbr
D3417	F

100



Hardinge CNC LATHE SMALL

Doosan

Memo

Doosan Lathe

1-Turn as per Folio FA954

Folio Rev: N/ADwg D3417 Rev: F

2-Deburr

11/3/15

20 6

110



QC2- Inspect parts off machine FAI/FAIB

QC

Memo

Quality Control

0.00

0.00

11/3/15

20 6

Work Order ID 67231

Monday, March 14, 2011 6:41:13 AM



Page 2

Item ID: D3417-9

Revision ID:

Item Name: Washer

Start Date: 3/14/2011 Start Qty: 20.00

Required Date: 3/17/2011 Req'd Qty: 20.00

Accept



Setup Start



Stop



Cust Item ID:

Customer:

Reference:

Approvals:

Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

120



QC

QC8- Inspect parts - second check

0.00

and 11/03/15

20 0

Quality Control

130



Packaging

Identify as per dwg & Stock Location: S3

0.00

counts

11/3/15

2028

Packaging

140



QC

QC21- Final Inspection - Work Order Release

0.00

Quality Control

Memo

0.00

11/3/15

CL 1103/15

Picklist Print

Monday, March 14, 2011 6:41:08 AM

Page 1

Work Order ID: 67231



Parent Item: D3417-9



Parent Item Name: Washer

Start Date: 3/14/2011

Required Date: 3/17/2011

Start Qty: 20.00

Required Qty: 20.00

Comments: Ipp Rev:A New Issue 10-08-03 JLM Verified By:DD

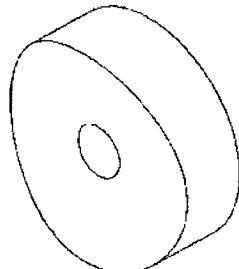
Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
MDELRINR1.2500 		Purchased		No			f	24.7010		0.623158		 SD 11/3/16	

DELRIN ROUND BAR 1.25"

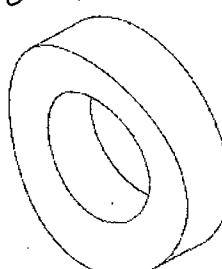
Location	Loc Qty	Loc Code
MAT	24.701	
— 114586	19.3	
114733	5.401	

8 7 6 5 4 3 2 1

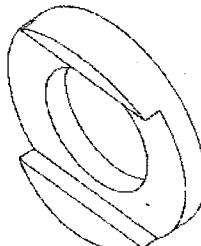
W/6 6723/



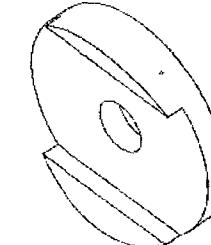
D3417-1 WASHER



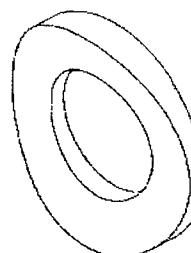
D3417-3 WASHER



D3417-5 WASHER



D3417-7 WASHER



D3417-9 WASHER

NOTES:

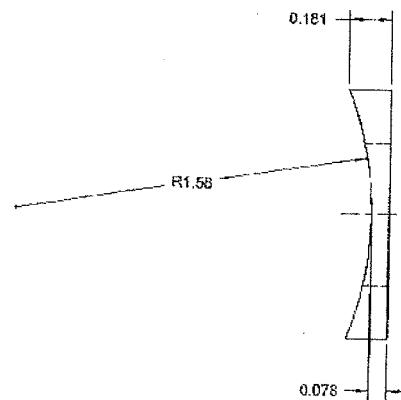
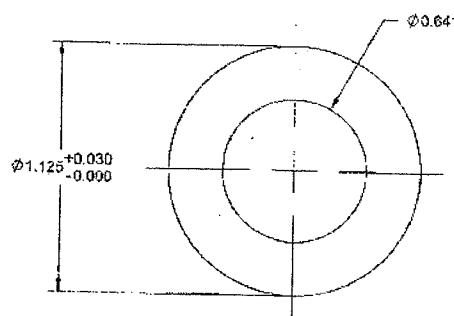
- 1) MATERIAL: BLACK DELRIN II 150E OR ACETRON GP ACETAL, ROD
REF DART SPEC M-DELRIN-R
OR BLACK DELRIN II 150E OR ACETRON GP ACETAL, BAR
REF DART SPEC M-DELRIN-B
OR BLACK DELRIN II 150E OR ACETRON GP ACETAL, SHEET
REF DART SPEC M-DELRIN-S
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 01B UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: D3417-1, 0.020 lbs
D3417-3, 0.010 lbs
D3417-5, 0.010 lbs
D3417-7, 0.010 lbs
D3417-9, 0.004 lbs

8 7 6 5 4 3 2 1

RELEASED
2010-09-15
W/6

F	ADD D3417-8 (ZN B5-3)	SC	10.07.26
E	ADD D3417-7 (ZN A2-2)	RF	09.06.30
D	ADD 5 WASHER (ZN B2-1, B2-2). REFORMAT TO 'B' SIZE & UPDATE TO CURRENT STANDARDS. REASON: INSTALLATION OF NEW TOW RING	AJS	09.07.08
C	REMOVE CBORE WIDEN	PH	05.05.30
B	CHANGE TO ROUND WASHER	PH	05.05.10
A	NEW ISSUE	PH	05.03.31
REV.	DESCRIPTION	BY	DATE
DESIGN	SC	DART AEROSPACE LTD	
DRAWN	SC	HAWKESBURY, ONTARIO, CANADA	
CHECKED	1	DRAWING NO.	REV. F
MFG. APPR.	1	D3417	SHEET 1 OF 3
APPROVED	1	TITLE	SCALE
DE APPR.	1	WASHER	NTS
DATE	10.07.26	COPRIGHT © 2005 BY DART AEROSPACE LTD DO NOT REPRODUCE OR DUPLICATE THIS DRAWING. THIS DRAWING IS THE PROPERTY OF DART AEROSPACE LTD. NOT TO BE USED FOR ANY PURPOSE OR IN ANY WAY OTHER THAN THAT FOR WHICH IT WAS ISSUED.	

W/0 67231



D3417-9 WASHER

RELEASED
2010-09-15

DESIGN	SC	DART AEROSPACE LTD	
DRAWN	SC	HAWKESBURY, ONTARIO, CANADA	
CHECKED	SC	DRAWING NO.	
MFG. APPR.	SC	D3417	REV. F
APPROVED	SC	SHEET 3 OF 3	
DE APPR.	SC	TITLE	SCALE
DATE	10.07.26	WASHER	NTS

Copyright © 2006 by DART AEROSPACE LTD
The information contained in this document is the sole property of DART AEROSPACE LTD.
It is to be used only for the purpose for which it was intended and is not to be distributed to any other organization without the express written permission of DART AEROSPACE LTD.

DART AEROSPACE LTD	Work Order:	WFO 67231
Description: Washer	Part Number:	D3417-9
Inspection Dwg: D3417 Rev: F		Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

Measured by:		Audited by:		Preliminary Approval:	
Date:	11/3/15	Date:	11/03/15	Date:	

Rev	Date	Change	Revised by	Approved
A	10.11.08	New Issue	KJ	